

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010696**Date Inspected:** 28-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Trial Assembly area

SMAW in the 4G position of the OBG segment 4AW corner joint at side plate to bottom plate , weld No. SEG-17A-007 at CW side. The welder is identified as #067571. ZPMC QC is identified as Mr.Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-4G(4F)-FCM-REPAIR-1 and repair procedure B-CWR904.

SMAW in the 4G position of the OBG segment 3BE corner joint at side plate to bottom plate , weld No. SEG-16A-008 at CW side. The welder is identified as #054467. ZPMC QC is identified as Mr.Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-4G(4F)-FCM-REPAIR-1 and repair procedure B-CWR921.

SMAW in the 4G position of the OBG segment 3BE corner joint at side plate to bottom plate , weld No. SEG-16A-007 at CB side. The welder is identified as #049769. ZPMC QC is identified as Mr.Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-4G(4F)-FCM-REPAIR-1 and repair procedure B-CWR921.

QA Verification UT performed after repair on portion of Side plate Splice joint of 4AE to 4BE at bike path side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded

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onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

OBW4A-004 and 005

QA Verification UT performed after repair on portion of corner joint deck plate to edge plate of 4AE to 4BE at bike path side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designations are as follows

CA008-002,004 and 006

CA012-002,004 and 006

QA Verification UT performed after repair on portion of bottom plate Splice joint of 3AW to 3BW . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

OBW3A-003

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
